

# Work Order ID 64218

November 30, 2010 12:32:11 PM

*Tony*

PRELIMINARY ISSUE

Page 1

Item ID: D4274-3  
Revision ID: PRELIM  
Item Name: Plate, Aft Support

Accept



Setup Start



Stop



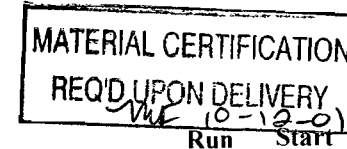
Start Date: 11/30/10 Start Qty: 2.00

Required Date: 11/30/10 Req'd Qty: 2.00



Cust Item ID:

Customer:



Run Start



Stop



Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D4274

PB1

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: *pbl*

Prog Rev: *pbl*

2-Deburr if necessary

*PB 10-11-30*

*(2)*

*PB 10-11-30*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

# Work Order ID 64218

November 30, 2010 12:32:11 PM



Item ID: D4274-3  
Revision ID: PRELIM  
Item Name: Plate, Aft Support

Accept



Setup Start



Stop



Start Date: 11/30/10 Start Qty: 2.00  
Required Date: 11/30/10 Req'd Qty: 2.00



Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:  
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00 - inspect to PB1

0.00

Day only

Dis 11/30 (x2)

130



Packaging

Packaging

Identify as per dwg & Stock Location: \_\_\_\_\_

Memo

0.00

0.00

Hebave

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

At least only Rev PB1 10/12/03

POSITIVE RECALL

EFFECTIVE

RELEASED

AUTH

DATE

MF 10-11-30

# Picklist Print

November 30, 2010 12:32:10 PM

Page 1

Work Order ID: 64218

Parent Item: D4274-3

Parent Item Name: Plate. Aft Support



Start Date: 11/30/10

Required Date: 11/30/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev:A 10.11.18 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	24.7523	0.357	0.751579			



304/316 0.125 Sheet



B10-11-30

Location

Loc Qty

Loc Code

MAT

24.7523

114799

24.7523

114799

②

DART AEROSPACE LTD		Work Order: 64218
Description: PLATE AFT Support		Part Number: D4274-3
Inspection Dwg: D4274-3, Rev: pbl		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .129	+ .005 - .001	.131	X		V HB02	
Ø .191	+ .005 - .001	.192	X		V	
Ø .53	+ .008 - .001	.530	X		V	
Ø .750	+ .005 - .001	.751	X		V	
4.25	± .030	4.252	X		V	
8.06	± .030	8.054	X		V	
5.91	± .030	5.919	X			
.92	± .030	.921	X		V	
.750	± .010	.749	X		V	
.310	± .010	.306	X		V	
.38	± .030	.383	X		V	
3.83	± .030	3.826	X		V	
1.02	± .030	1.024	X		V	
8.95	± .030	8.916	X		V PROB2	
2.80	± .030	2.799	X		V	
1.05	± .030	1.054	X		V	
.66	± .030	.598	X		V	
1.20	± .030	1.209	X		V	
1.10	± .030	1.090	X		V	
.75	± .030	.756	X		V	
3.000	± .010	3.003	X		V	
1.500	± .010	1.501	X		V	
2.300	± .010	2.299	X			

Measured by: WB	Audited by: S	Prototype Approval:
Date: 10-11-30	Date: 10/11/30	Date:

to PBI Day only

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order: 64218
Description: PLATE Aft Support		Part Number: D4274-3
Inspection Dwg: D4274-3, Rev: pbl		Page 1 of 1

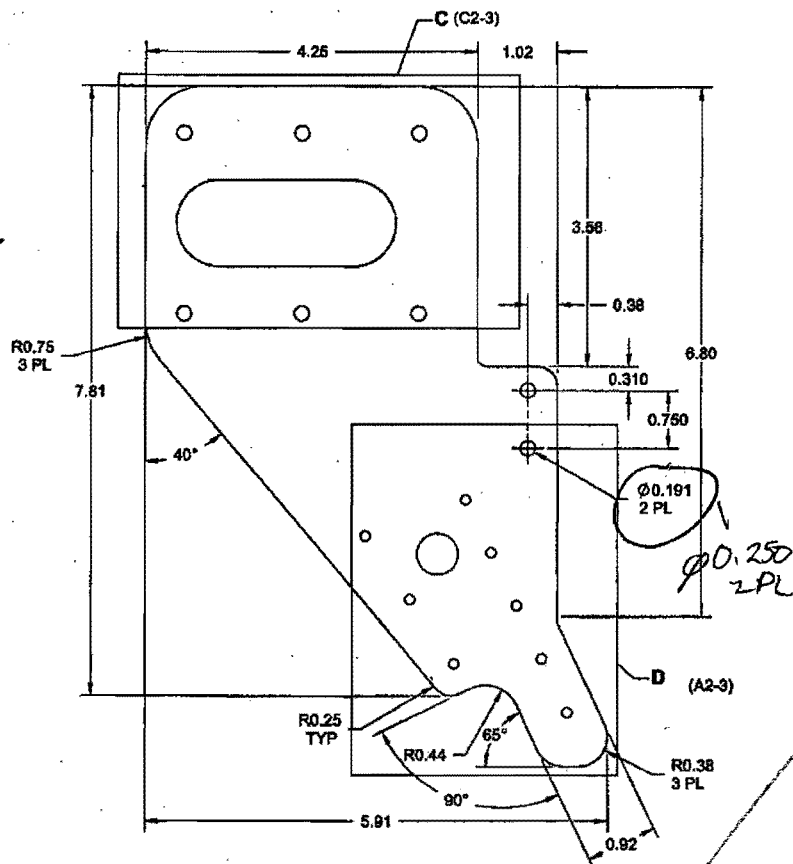
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

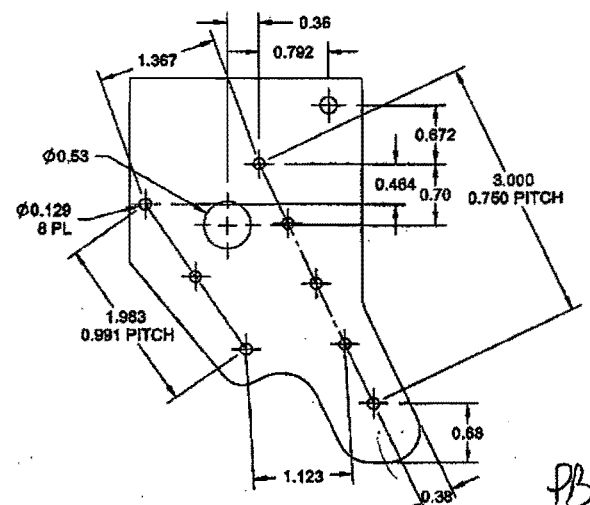
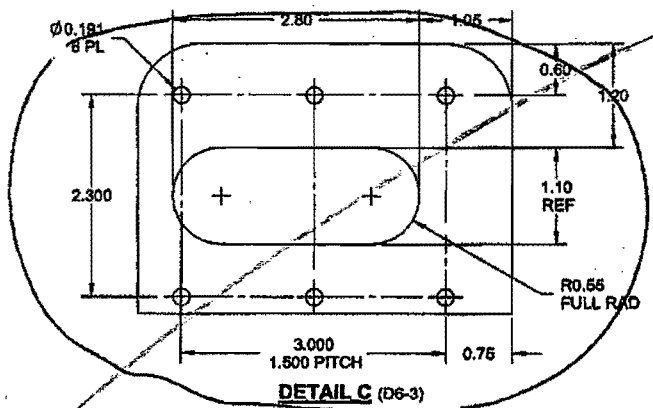
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.361	±.010	1.364	✓		V B02	
.36	±.030	.36	✓		V	
.792	±.010	.792	✓		V	
.672	±.010	.670	✓		V	
.464	±.010	.464	✓		V	
.70	±.030	.70	✓		V	
.68	±.030	.681	✓		V	
.38	±.030	.383	✓		V	
1.123	±.010	1.123	✓		V	
1.983	±.010	1.983	✓		V	
.991	±.010	.990	✓		V	
.125	±.010	.118	✓		V	
3.000	±.010	3.000	✓		V ED 00926	
.750	±.010	.750	✓		V ED 00926	

Measured by: PB	Audited by: S	Prototype Approval: —
Date: 10-11-36	Date: 10/14/30 to PBI Dwg only	Date: —

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



**D4274-3 PLATE, AFT SUPPORT**

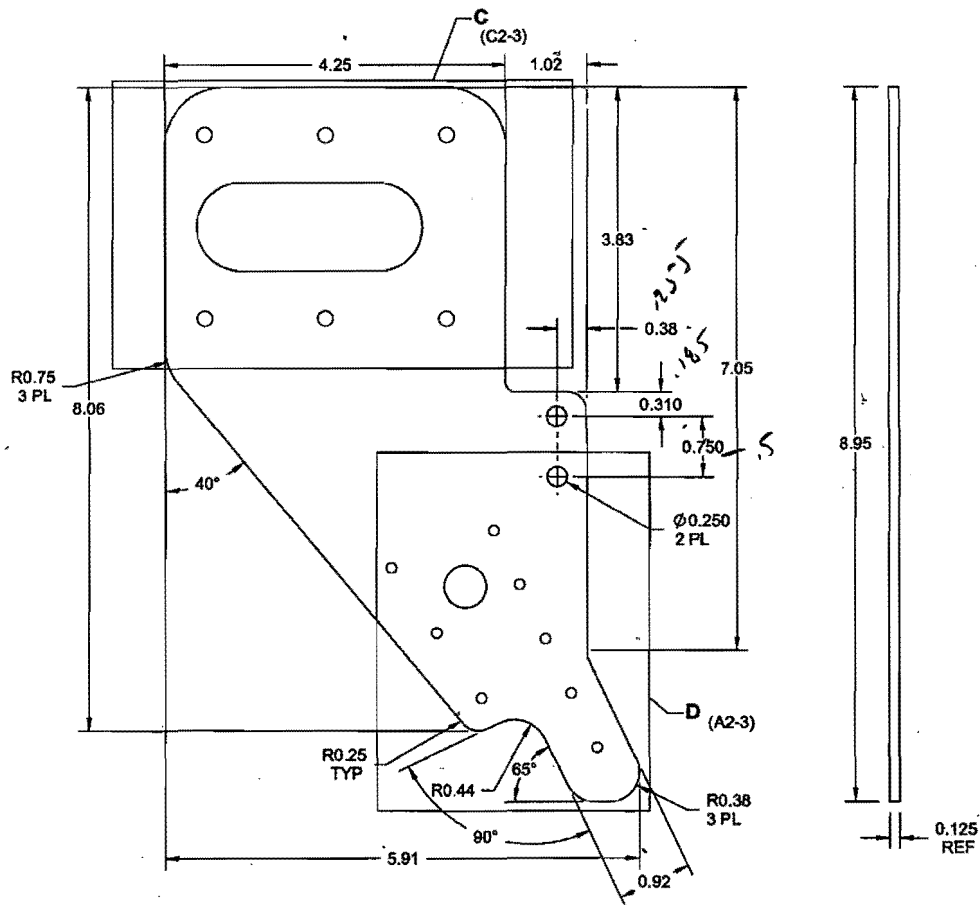


**DETAIL D (B5-3)**

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK PER MIL-S-6058 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA OR M303S11GA
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.94 lbs

**PRELIMINARY ISSUE**  
Nov 17, 2010 fl.

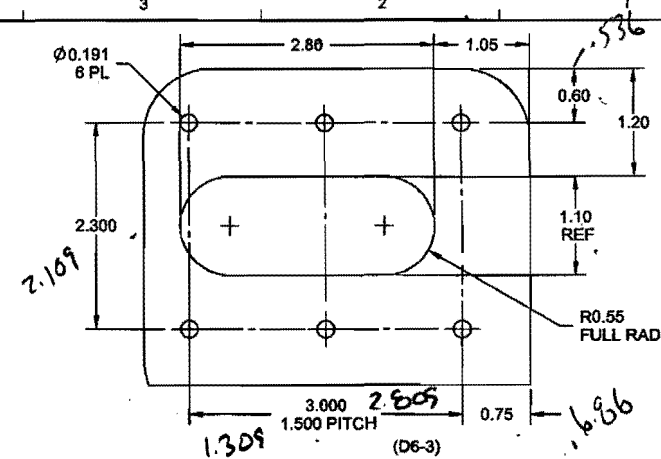
DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. <i>1</i>
MFG. APPR.	<i>[Signature]</i>	<b>D4274</b>	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		<b>PLATES, BASKET SUPPORT</b>	NTS
DATE	10.11.12	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT AND ALL INFORMATION CONTAINED HEREIN IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE FOR ANY PURPOSES OR COPIED OR REPRODUCED TO ANY OTHER PERSON OR ENTITY WITHOUT PERMISSION FROM DART AEROSPACE LTD.	



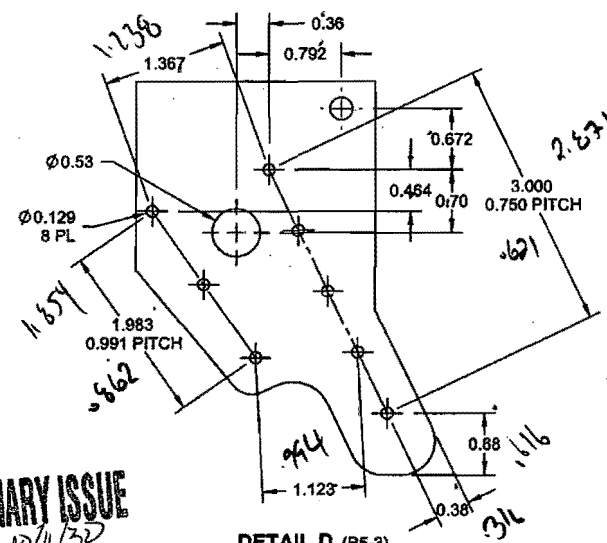
**D4274-3 PLATE, AFT SUPPORT**

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.97 lbs



**DETAIL C**



**DETAIL D (B5-3)**

**PRELIMINARY ISSUE**  
10/11/30

DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PB1
MFG. APPR.		<b>D4274</b>	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>PLATES, BASKET SUPPORT</b>	NTS
DATE	10.11.30	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

## Receiving Report

Date: 10/5/31

Batch No: M114795

Supplier: MAGNA

Dart P/O: 11923

Packing Slip: Yes ☒ No ☐  
 Invoice: Yes ☐ No ☒  
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐  
 Waybill Attached: Yes ☐ No ☒ N/A ☐  
 Shipment Complete: Yes ☒ No ☐ N/A ☐  
 QC6 Inspection ☒ N/A ☐  
 Work Order 810131 N/A ☒

**Discrepancies**

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12   

Production/Admin:     
 Date: 10/5/31  
 Received/Costing:     
 Initial:   

Location



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Page 1 of 1

All amounts are calculated in domestic currency.

Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID\Vendor Name		VC-MAG002	Magna Stainless								
PO11973	1		M304S16GA	sf	5/31/2010	5/31/2010	128.0000	\$5.03	0.0000	0	\$643.20
CAD	No		304/316 Sheet .063	sf	128.0000	DCUSER		\$643.20	0.0000	0	
			114799								
	2		M304S11GA	sf	5/31/2010	5/31/2010	128.0000	\$10.47	0.0000	0	\$1,340.16
	No		304/316 0.125 Sheet	sf	128.0000	DCUSER		\$1,340.16	0.0000	0	
			114799								
	3		M6061T6S.050	sf	5/31/2010	5/31/2010	128.0000	\$2.88	0.0000	0	\$368.00
	No		6061-T6 .050 Sheet	sf	128.0000	DCUSER		\$368.00	0.0000	0	
			114799								
Total Received Quantity:										384.0000	
Total Qty to Inspect (PO U/M):										0.0000	
Total Reject Quantity:										0.0000	
Total Receipt Value:										\$2,351.36	
Total Balance Due Quantity:										0.0000	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

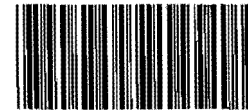
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Magna Stainless

5775 Kieran St, Saint-Laurent, Quebec H4S 0A3  
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105



## PACKING LIST

Page 1 of 1

I027686

SOLD TO:  
DART AEROSPACE LTD  
1270 ABERDEEN STREET  
HAWKESBURY, ON K6A 1K7

SHIP TO:  
DART AEROSPACE LTD  
1270 ABERDEEN STREET  
HAWKESBURY, ON K6A 1K7

### SPECIAL INSTRUCTIONS

\*\*\*\*\*STOCK\*\*\*\*\*

Contact: CHANTAL LAVOIE

Ship Terms: PREPAID

MTR:Y

Currency		Sales Person	Customer Phone	Customer Fax	Customer PO		
CANADIAN DOLLARS		ERYCK BLAIS	(613) 632-5200	(613) 632-1053	11973		
Sales Order	Terms		Ship Via		Date Ordered	Date Required	Date Shipped
W030353	NET 30 DAYS		NIR:R-557065-1		05/27/10	05/31/10	05/31/10

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
4		PC	ALUMINUM SHEET ASH 6061 T6 .050" x 48" x 96" 92 LB / 4 PC MATERIAL IS PER QQA 250/11 AND PER AMS 4027	L037272	1615261	4
4		PC	STAINLESS SHEET SSH 304 2B 16ga x 48" x 96" 336 LB / 4 PC MATERIAL AS PER ASTM A240	L038199	99020048	4
4		PC	SSH 304 2B 11ga x 48" x 96" 672 LB / 4 PC MATERIAL AS PER ASTM A240	I037542	7281937	4
Skids: 1				Approx Weight:	1,100 LB	

Received by: \_\_\_\_\_ Date: \_\_\_\_\_ Signature: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

2009367

C1583

V/0080230171

DATE : 2007-04-03

PROD. REF. : 0000216290/002

NRBST : 01946/02

PAGE : 1/ 2

INSPECTION CERTIFICATE

CUSTOMER : ALERIS ALUMINUM US SALES INC.

YOUR ORDER NUMBER :  
CUR ORDER NUMBER :  
DOCUMENT NUMBER :

810105/31

**Aleris**  
Europe

Aleris Aluminum Duffel BVBA  
A. Stocletlaan 67, 2570 Duffel - Belgium

DESCRIPTION : ALU SHEETS (STENC) AA 6061-T6 AMS-QQA 250/11 AMS 4027M ASTM B209-04  
DIMENSIONS : 96" X 48" X .05"  
ARTICLE NO.:

CAST  
NUMBER

CHEMICAL COMPOSITION (%)

	SI	FE	CU	MN	MG	CR	TI	ZN
MIN	0,40		0,15		0,8	0,04		
MAX	0,8	0,7	0,40	0,15	1,2	0,35	0,15	0,25
1615261	0,65	0,4	0,21	0,10	1,1	0,16	0,02	0,02

OTHERS : EACH : MIN 0,05 MAX  
TOTAL : MIN 0,15 MAX

MECHANICAL PROPERTIES

(T) = TRANSVERSAL (L) = LONGITUDINAL  
1 N/MM2 = 1 MPA = 0,1 HBAR = 0,102 KG/MM2 = 0,145 KSI  
/A = REAR END /M = MIDDLE /V = FRONT END /O = RANDOM SAMPLING

	RM KSI	RP02 KSI	A %
MIN	42	35	10
MAX			
/A	48	40	15
/M	48	40	15
/V	48	40	15

Aleris Aluminum Duffel BVBA

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

V/0080230171

DATE : 2007-04-03

PROD. REF. : 0000216290/002

NRBST : 01946/02

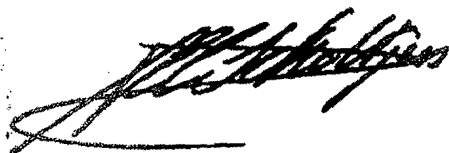
PAGE : 2/ 2

**Aleris**  
Europe

Aleris Aluminum Duffel BVBA  
A. Sociëteit 27, 2570 Duffel - Belgium

SOLUTION HEAT TREATMENT COIL NUMBER  
001 STENCILLING : WEEK 10 / YEAR 2007

HEAD OF LABORATORY,  
XAVIER SCHELTJENS



Aleris Aluminum Duffel BVBA



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



## INSPECTION CERTIFICATE

CERTIFICATE NO.: YS-990165

CUSTOMER: MAGNA STAINLESS INC(DIV OF CANADIAN SPECIALTY METALS INC.)

INVOICE NO.: SSACAE40101TE9

CREDIT NUMBER: I700584

DESCRIPTION: STAINLESS STEEL SHEETS

DATE: 12 MAR, 2010

*20.4 + 1.5mm = 20.9mm*

P/L NO.	SIZE	PCS	N.W. (KG)	SPEC	HEAT NO.	REFERENCE NO.
1	0.9MM X 1219MM X 2438MM	58	1214	304-2B/PAPER	9901419TM -990 20040	YERYCA9901A-01A
2	0.9MM X 1219MM X 2438MM	58	1217	304-2B/PAPER	9901419TM -990 20040	YERYCA9901A-01AB
3	0.9MM X 1219MM X 3048MM	46	1204	304-2B/PAPER	9901419TM -990 20040	YERYCA9901A-02A
4	0.9MM X 1219MM X 3048MM	46	1205	304-2B/PAPER	9901419TM -990 20040	YERYCA9901A-02AB
5	0.9MM X 1219MM X 3657MM	46	1445	304-2B/PAPER	9901419TM -990 20040	YERYCA9901A-03A
6	1.5MM X 1219MM X 2438MM	50	1757	304-2B/PAPER	9901430YU -990 20048	YERYCA9901A-04A
7	1.5MM X 1219MM X 2438MM	50	1760	304-2B/PAPER	9901430YU -990 20048	YERYCA9901A-05A
8	1.5MM X 1219MM X 2438MM	50	1756	304-2B/PAPER	9901430YU -990 20048	YERYCA9901A-06A
9	1.5MM X 1219MM X 2438MM	35	1231	304-2B/PAPER	9901430YU -990 20048	YERYCA9901A-06AB
10	2.5MM X 1219MM X 3048MM	16	1168	304-2B/PAPER	9902069YU -990 20188	YERYCA9901A-07A

### Chemical Composition

### Mechanical Test

P/L NO.	C	Si	Mn	P	S	Ni	Cr	N	Cu	Mo	Y.S.(0.2%) N/mm2	T.S. N/mm2	Elongation %	Hardness HV
1	0.041	0.300	1.300	0.029	0.001	8.000	18.09	-	-	-	281	625	56.0	157.0
2	0.041	0.300	1.300	0.029	0.001	8.000	18.09	-	-	-	281	625	56.0	157.0
3	0.041	0.300	1.300	0.029	0.001	8.000	18.09	-	-	-	281	625	56.0	157.0
4	0.041	0.300	1.300	0.029	0.001	8.000	18.09	-	-	-	281	625	56.0	157.0
5	0.041	0.300	1.300	0.029	0.001	8.000	18.09	-	-	-	281	625	56.0	157.0
6	0.044	0.530	1.190	0.036	0.001	8.020	18.27	0.0250	0.1900	0.0900	299	665	53.0	164.0
7	0.044	0.530	1.190	0.036	0.001	8.020	18.27	0.0250	0.1900	0.0900	299	665	53.0	164.0
8	0.044	0.530	1.190	0.036	0.001	8.020	18.27	0.0250	0.1900	0.0900	299	665	53.0	164.0
9	0.044	0.530	1.190	0.036	0.001	8.020	18.27	0.0250	0.1900	0.0900	299	665	53.0	164.0
10	0.052	0.540	1.160	0.039	0.005	8.020	18.20	0.0270	0.2400	0.0900	309	648	53.0	177.0

Remark: 1. We hereby certify that the products described herein have been manufactured and tested with satisfactory results in accordance with the requirement of the above material specification.

2. As per ASTM A240/480 standard.

3. The material described above has been detected with free irradiation.

YIEH CORPORATION LIMITED Q.C. MANAGER

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**AK Steel Corporation**  
**Metallurgical Test Report**  
**Rockport Works**  
**Rockport, IN 47635**

Page 1

Load No. 9220693

SRN No. 9220693

RECEIVED

SHIP TO

MILL ORDER NO. 241851-2349 PROCESSOR ORDER NO. S17824 BUYERS ORDER NO. S17824

PART NO.

ENGLISH UNITS --PRODUCT-- METRIC UNITS  
.1250 NOM 48.0000 X COIL

COIL ID	PIECE	HEAT	PARENT COIL ID	NET WEIGHT	OUTSIDE PROCESSOR ID	
212487-04BA	1	7281937	0212487-04B	13,160 LBS. 5,969 KG.	478338401	P041548
212487-04BB	1	7281937	0212487-04B	13,180 LBS. 5,978 KG.	478338402	P041549
212487-04BC	1	7281937	0212487-04B	13,150 LBS. 5,965 KG.	478338403	P041550
TOTAL COILS	TOTAL PIECES			TOTAL NET WEIGHT		
3	3			39,490 LBS. 17,912 KG.		

L=Lab Analysis of Heat

P=Product Analysis of Parent Coil

**CHEMICAL ANALYSIS**

ID	C	MN	P	S	SI	CR	NI	MO	N	CU						
L 7281937	.022	1.491	.029	.0011	.369	18.23	8.24	.23	.0330	.38						

SHIPPING DATE: 02/06/2009

REMARKS:

NO INTENTIONAL ADDITIONS OF MERCURY OR MERCURY COMPOUNDS WERE  
MADE OR USED THROUGHOUT THE PROCESSING AND TESTING OF THIS MATERIAL.  
MATERIAL FREE OF RADIOACTIVE ISOTOPES  
MELTED AND MANUFACTURED IN THE USA

**PRODUCT DESCRIPTION**

CR SHT TYPE 304/304L STAINLESS #28 FINISH SLIT EDGE \* ASTM A 240 -08 \* ASTM A 480 -08 EX PARA 25.1.1.3 COIL WILL BE TAGGED ON C  
OUTSIDE ONLY \* ASME SA-240 SECTION II PART A (2004 ED. 2005 ADDENDA) \* ASME SA-480 SECTION II PART A (2004 ED. 2005 ADDENDA) \* AS  
TM A 262 -02AKZ PRACTICE E \* EN 10204: 2004 (E) TYPE 3.1 \* ASTM A 866 -03 EX 7.1 TEST SPECIMENS WILL BE SELECTED IN THE TRANSVE  
RSE TEST DIRECTION IN ALL CASES \* AMS 5511 H

PARENT COIL ID	POS (F/T)	DIR (L, T, D)	COND	%ELONG	TENSILE STRENGTH (KSI)	Y.S. 1% OFFSET (KSI)	ROCKWELL HARDNESS Tall	ROCKWELL HARDNESS Front			
0212487-04B	T	T	A.S.T.M	52.7	92.2	49.9	B 88	B 87			

\*\*\* CONTINUED ON NEXT PAGE \*\*\*

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO11973**

Purchase Order Date 5/27/10

PO Print Date 5/27/10

Page Number 1 of 2

Order From :

VC-MAG002

MAGNA STAINLESS  
5775 RUE KIERAN  
ST LAURENT, QC H4S 0A3  
CA

Contact Name

Vendor Phone

Vendor Fax

Vendor Account Nbr

800 363 6646

514 339 1105

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**FAKED**  
*05/27/10*

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M304S16GA	304/316 Sheet .063	5/31/10 Yes	128.00 sf	Yours ppd	\$5.0250	\$643.20
		Special Inst: MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH AS PER MIL-S-5059 OR AMS 5513 OR AMS 5524 OR ASTM A240 OR ASME SA240					
2	M304S11GA	304/316 0.125 Sheet	5/31/10 Yes	128.00 sf	Yours ppd	\$10.4700	\$1,340.16
		Special Inst: AS ABOVE					
3	M6061T6S.050	6061-T6 .050 Sheet	5/31/10 Yes	✓ 128.00 sf	Yours ppd	\$2.8750	\$368.00
		Special Inst: MATERIAL: 6061-T6/T62 ALUMINUM SHEET AS PER QQ-A-250/11 OR AMS-QQ-A- 250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209					

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

Change Nbr: 1

Change Date: 5/27/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO11973**

Purchase Order Date 5/27/10

PO Print Date 5/27/10

Page Number 2 of 2

Order From :

VC-MAG002

MAGNA STAINLESS  
5775 RUE KIERAN  
ST LAURENT, QC H4S 0A3  
CA

Contact Name

Vendor Phone 800 363 6646

Vendor Fax 514 339 1105

Vendor Account Nbr

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

PO Total:

\$2,351.36

MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY

Change Nbr: 1

Change Date: 5/27/10

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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